

303 500

Work Order ID 73802

Thursday, September 15, 2011 12:34:38 PM



Page 1

Item ID: D3439-3

Accept



Setup Start



Revision ID:

Item Name: Stud

Stop



Start Date: 9/15/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3439	B

100



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

40

Ø

 TURN AS PER FOLIO FA959
 FOLIO REV: A1
 DWG REV: _____

DEBURR

110



QC2- Inspect parts off machine FA1/FA1B

0.00

QC

Memo

0.00

Quality Control

40

Ø

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts - second check

0.00

SL 11-10-14

QC

Memo

0.00

Quality Control

130



Identify as per dwg & Stock Location

GA

0.00

HOK

SP 11-10-13

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/10/18 JG

ME
11-10-18

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, September 15, 2011 12:34:35 PM

Work Order ID: 73802



Parent Item: D3439-3



Parent Item Name: Stud

Start Date: 9/15/2011

Required Date: 9/23/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 10.09.08 new issue verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 		Purchased	No			100	f	35.9300	0.113	4.757895 		<i>anl/s 11/10/17</i>	

303 Round Bar 0.500"

Location	Loc Qty	Loc Code
MAT028	35.93	
117143	11.34	
118271	11.9	
118509	12.69	

4.757895

4,500

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W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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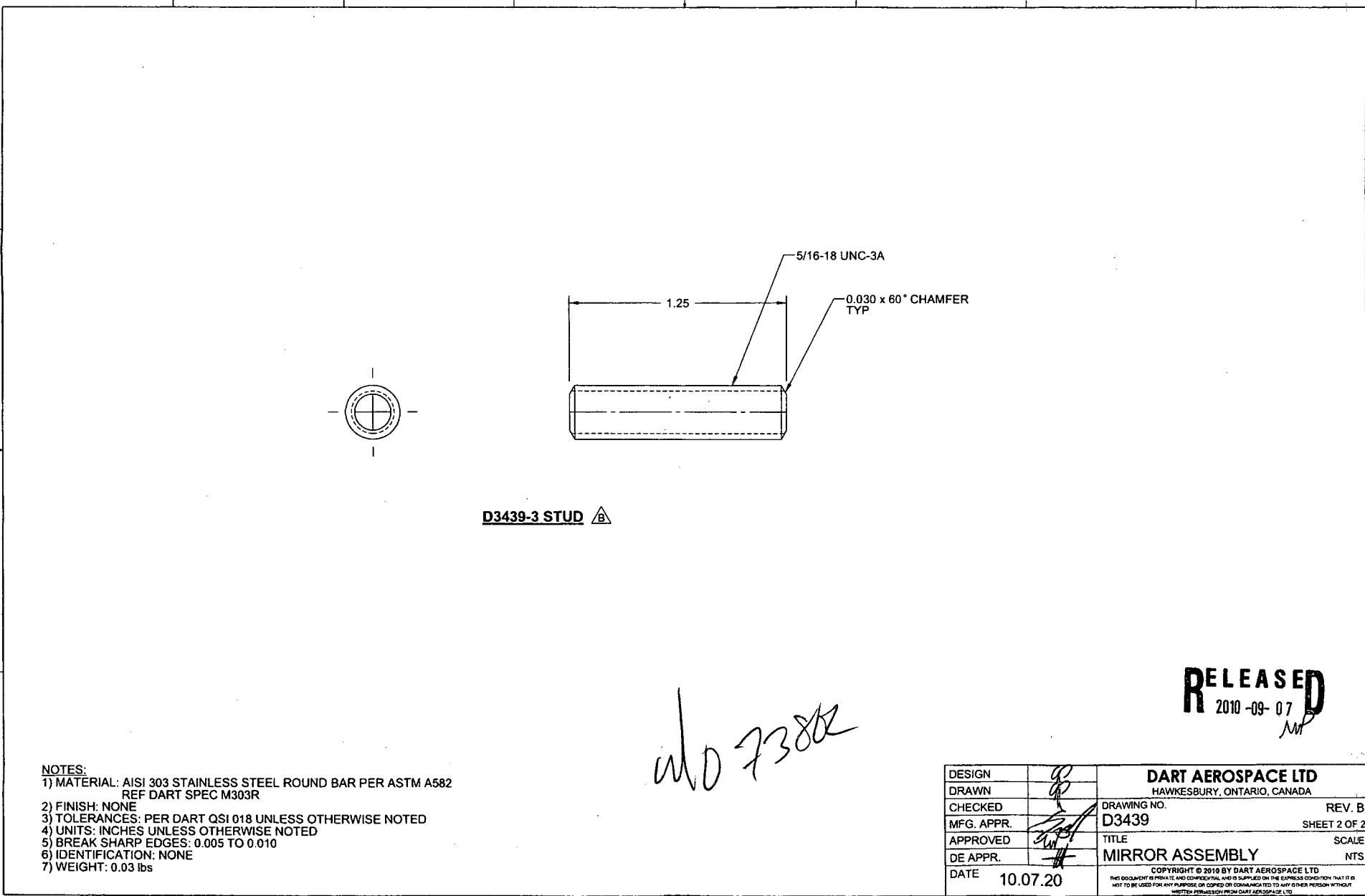
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Stud	Part Number:	D3439-3
Inspection Dwg: D3439	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>SL</u> / <u>cmf</u>	Audited by:	<u>SL</u>	Preliminary Approval:	
Date:	11/10/17	Date:	11-10-17	Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	DR



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

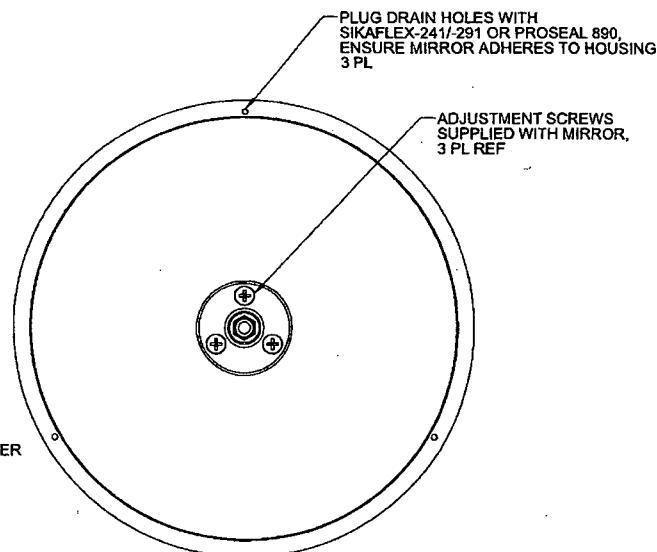
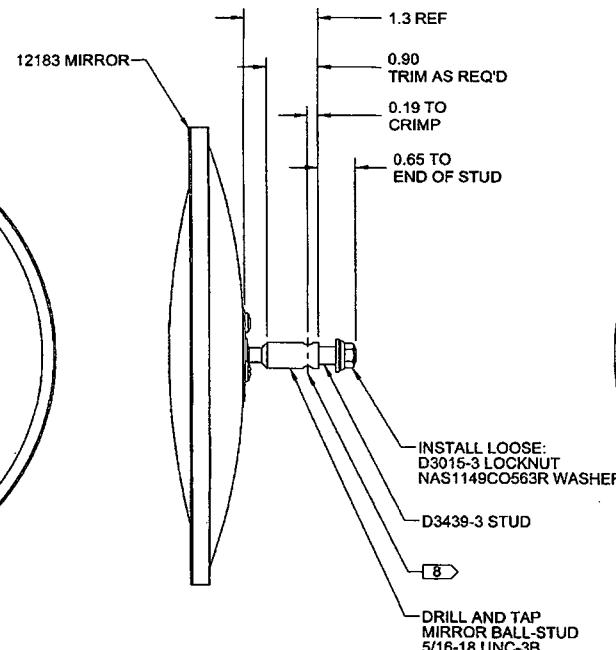
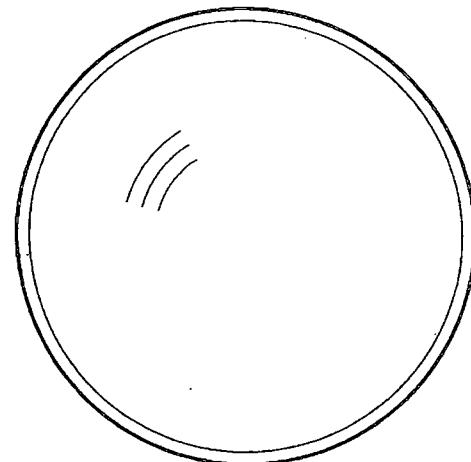
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D3439-101 MIRROR ASSEMBLY

NOTES:

- 1) MATERIAL: MIRROR= 8" ROUND CONVEX MIRROR W/ STAINLESS STEEL CASE
CENTER-MOUNT BALL-STUD W/ 1/4-20X 1" DEEP FEMALE THREAD
GROTE INDUSTRIES, 2600 LANIER DRIVE, MADISON, INDIANA 47250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3439-101" USING REMOVEABLE TAG
- 7) WEIGHT: 1.18 lbs
- 8) TO INSTALL D3439-3 STUD:
 - APPLY LOCTITE 262 TO THREADS BEING INSTALLED INTO MIRROR BALL-STUD
 - THREAD D3439-3 STUD INTO MIRROR BALL-STUD
 - CRIMP MIRROR BALL-STUD ON OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.015-0.030 USING R0.125

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3439-101	MIRROR ASSEMBLY, 8"
2	1	12183	MIRROR 8" (GROTE)
3	1	D3015-3	LOCKNUT
4	1	D3439-3	STUD
5	1	NAS1149CO563R	WASHER (OR AN960JD516)

RELEASED
2010-09-07
AM

B	REDRAW, ADD -3 (WAS PURCHASED/TRIMMED BOLT). RMV LPS	CP	10.07.20
A	NEW ISSUE	CP	05.05.27
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	REV. B		
MFG. APPR.	D3439		
APPROVED	SHEET 1 OF 2		
DE APPR.	TITLE MIRROR ASSEMBLY		
DATE	SCALE NTS		
10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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